

## Process Sheet

Date: Tuesday, 5/23/2006 8:31:25 AM  
 Kim Johnston

Split 06/05/31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET  
 Job Number : 27188-2  
 Estimate Number : 10364  
 P.O. Number : N/A Part Number : D3046041  
 This Issue : 5/23/2006 S.O. No. : N/A Drawing Number : D3046 REV. A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A  
 Previous Run : 25924 Material : N/A Due Date : 6/2/2006 Qty: 16 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : 06.05.23  
 Comment : Est: A 01.08.27 New issue SM/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30461 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 LUG BRACKET

Qty Part Number Description Batch  
 1 D3046-1 Lug Bracket

B 2715 B27196

2.0 D30463 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 LUG BRACKET

Pick:

Qty Part Number Description Batch  
 1 D3046-3 ( Bell P/N: 206-052-106-1) Lug Bracket

Batch ③ B 26224 ① B 27197  
 12 B 27197

Return Authorization #  
 Bell original batch#

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046
- 2- Counter sink inside holes of D3046-1 as per Dwg D3046
- 3- Deburr

SAD

SB 06/05/31

⑫

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A 06.05.23

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27188

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.6

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

N/A *5-25*

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7.0

MS20426AD57

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 160.0000 Each(s)

Rivet

Qty Part Number  
10 MS20426AD5-7

Description Batch  
Rivet *M 3676 M 7681*

SMALL & MEDIUM FAB RESOURCE 1

8.0

SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3046

*SB 06/05/31 (12)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 06/05/31 12*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*G.M. 06-05-31 (4)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FC 06 05 31 (12)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *FG*

*FC 06 05 31 (12)*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27188

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*Doc 06/15/31*

*12*

Job Completion



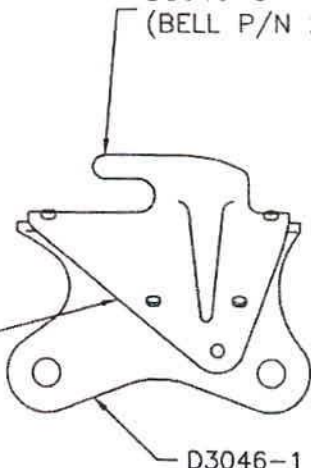
*CU 06/15/31*



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3046
DATE 01.08.23		TITLE LUG BRACKET
A	01.08.23	NEW ISSUE
		REV. A
		SHEET 1 OF 2
		SCALE 1:2

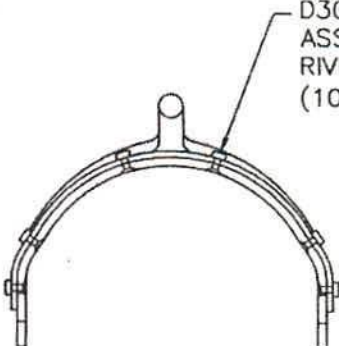
D3046-3  
(BELL P/N 206-052-106-1)



D3046-1

CENTER D3046-3  
ON D3046-1

TRANSFER DRILL  $\varnothing 0.156$  HOLES  
FROM D3046-3 TO D3046-1.  
C'SINK  $\varnothing 0.286 \times 100'$   
D3046-1 INSIDE BORE.  
ASSEMBLE USING MS20426AD5-7  
RIVETS.  
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

RELEASED  
01.08.23

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NO. 27188  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHIP COPY